

Work Order ID 139475

139475

Page 1

Monday, November 30, 2015 11:44:34 AM

Item ID: D2372-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cam Lever
 Start Date: 11/30/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/30/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: DEC 01 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2372	B								

100 PURCHASING 0.00
100 CX DEC 04 2015 10
 Purchasing Memo 0.00
 Purchasing Issue P/O: 30662
 Possible Supplier: Essentra
 Supplier part#: KCL-208
 C OF C is required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110 10X SP15-12-08
 Packaging Memo 0.00
 Packaging

120 QC6- Inspect dimensions to drawing 0.00
120 (10) DAS 38 9-89
 QC Memo 0.00
 Quality Control DEC 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
OTHER :																																																																																																																															

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 	0.00				10			
130						DEC 10 2015			
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						ML5			
QC	Memo	0.02				DEC 10 2015			
Quality Control									

ML5 DEC 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
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Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

Monday, November 30, 2015 11:44:34 AM

Page 1

Work Order ID: 139475

139475

Parent Item: D2372-1

D2372-1

Parent Item Name: Cam Lever

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.02.07 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
KCL-208		Purchased		No		110	Each	0.0000	1	10			
KCL-208									**				
Cam Lever													

10X SP15-12-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

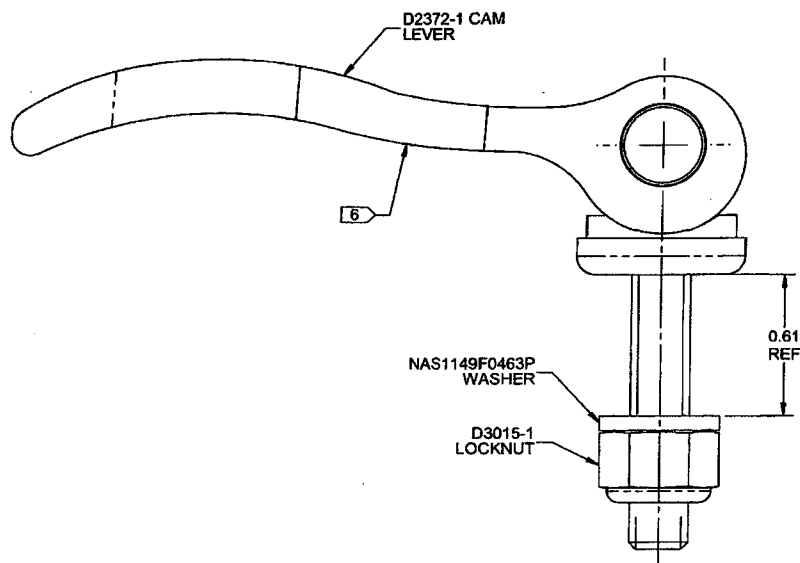
Work Order update only ☐

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Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
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Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

ITEM	QTY D2372	PART NUMBER	DESCRIPTION
	X	D2372	QUICK RELEASE
1	1	D2372-1	CAM LEVER
2	1	D3015-1	LOCKNUT
3	1	NAS1149F0463P	WASHER

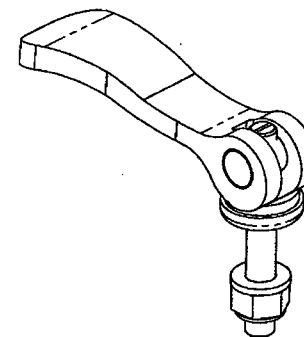
SPECIFICATION CONTROL DRAWING



D2372 QUICK RELEASE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 139475 ULS
15-12-01



NOTES:

- 1) MATERIAL: SEE SHEET 2
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2372" AND B/N "BXXXXX" PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 0.11 lbs

RELEASED
R 2012-02-06
JW

B	RE-DRAWN IAW QSI 043/044; SUPPLIER AND SUPPLIER P/N WERE "NORCO" AND "25-S129-01". REF: PART2-159.	MB	12.01.31
A	NEW ISSUE	BW	95.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2372	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		QUICK RELEASE	NTS
DATE	12.01.31	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



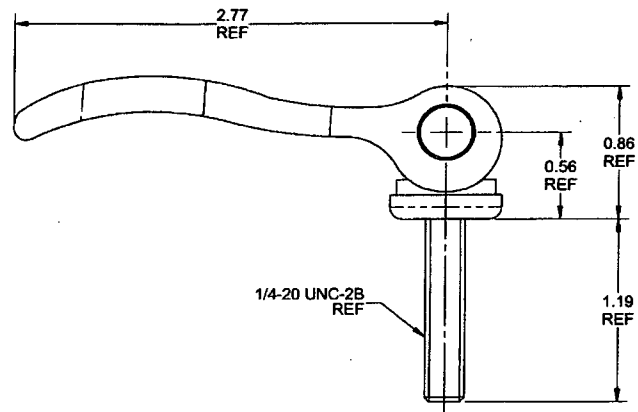
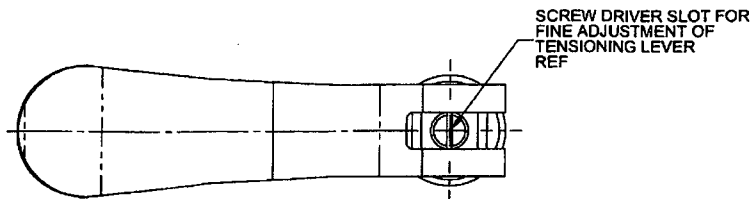
WORK ORDER NON-CONFORMANCE / UPDATE

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Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

SPECIFICATION CONTROL DRAWING



D2372-1 CAM LEVER

DART PART NUMBER	DESCRIPTION	SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	WEIGHT
D2372-1	CAM LEVER	REID TOOLS (PREFERRED)	KCL-208	HANDLE: ALUMINUM	0.10 lbs
		McMASTER-CARR (ALTERNATE)	5720K52	CAM WASHER: NYLON THREADED STUD, PIN, CAP WASHER: STAINLESS STEEL	

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE TABLE

RELEASED
2012-02-06

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	GP	DRAWING NO. D2372	REV. B
MFG. APPR.	GP	SHEET 2 OF 2	
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	QUICK RELEASE	NTS
DATE	12.01.31	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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				OTHER :							



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30662

Purchase Order Date 12/4/2015

PO Print Date 12/4/2015

Page Number 1 of 2

Order From :

VU-REI001

Ship To : DART AEROSPACE LTD

ESSENTRA COMPONENTS
62919 COLLECTION CENTRE DRIVE
CHICAGO, IL 60693-0629
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 800 253 0421

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

FAXED

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	CBL-460	Loop Sleeve	12/9/2015 Yes 12/9/2015		50.00 Each	\$0.26	\$13.00
Line Total:							\$13.00
2	KCL-208 AS PER DWG D2372 REV. B B139475	Cam Lever	12/9/2015 Yes 12/9/2015		10.00 Each	\$22.28	\$222.80
Line Total:							\$222.80
3	KBP-504 AS PER DWG D3801 REV. B B139555	Hand Retractable Spring Plunger	12/9/2015 Yes 12/9/2015		6.00 Each	\$25.84	\$155.04

Note:

12/4/2015

**ESSENTRA**

COMPONENTS

7240 Global Drive
Louisville, KY 40258
Phone: 800-847-0486
Fax: 814-898-1638
www.essentracomponents.com

DELIVERY NOTE#:

**P86892001946553**

CUSTOMER PO#

**PO30662**

Bill To: DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

Ship To: DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA

**Load Number: 166559**

CUSTOMER NO		ORDER #	SHIPPED VIA		SHIP DATE
45215650		1946553	FXIE FedEx Int'l Economy		12/04/15
ORD LN	Item Description	Original Quantity	Quantity Shipped	Backorder Quantity	UM
1	CBL-460 Z.P.COPPER LOOP SLEEVE FOR 1/16" CABLE Country Of Origin: US	50.000	50.000		EA
2	KCL-208 2.77 SS ADJ CAM LEVER 1/4-20 X 1.18 STUD Country Of Origin: DE	10.000	10.000		EA
3	KBP-504 3/8-24 NON-LOCKING SS PULL INDEXING PLUNGER Country Of Origin: DE	6.000	6.000		EA

SP15-12-08

This is to certify that the above material shipped against your purchase order is in conformance with all known requirements, specifications and drawings in effect at the time of manufacture. All applicable physical, functional, dimensional and material test reports are on file at our facility, and may be inspected by your representative upon request.

Jeff Gillespie
Quality Manager

1. Vendor(Name and Address)

7240 Global Drive
Louisville, KY 40258

Commercial Invoice

2. Date of direct shipment to Canada

December 04, 2015

3. Consignee (Name and address) DART AEROSPACE 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7 CANADA		4. Purchasers name and address (If other than consignee) DART AEROSPACE LTD 1270 ABERDEEN ST HAWKESBURY, ON K6A 1K7 CA		
5. Other references (Include Purchase order's number) LOAD: 166559		6. Country of origin GERMANY		
7. County of transshipment CANADA		8. Transportation: Give Mode and Place of Direct Shipment to Canada FXIE		
9. Currency of Settlement US Dollars		10. Item Description PLASTIC PROTECTIVE CAPS & PLUGS TARIFF ITEM# 3923.50.0000-7		
Pkgs.	Item Description	Quantity Shipped	Unit Price	Total
10 CTNS	KCL-208	10.000PCS	22.26	222.80
6 CTNS	KBP-504	6.000PCS	25.84	155.04
		SP15-12-08		
Shipping Clerk: Michael Kovach		Part Weight 1.84	Tare Weight 1.86	Invoice Total 377.84